



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2857-2
Job Sheet 212567



Part No: D2857-2

Job Qty: 12 pcs

Part Name: Hinge Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/26/20

Job Tracking No:

Due Date: 9/30/20

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV C IPP C 00.06.22 Removed P/O for powder coat EC IPP D 06.03.30

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	9/29/20	9/29/20	0.00	2.08	Bandsaw - 1		JK 20-09-14
110	HAAS 4 Axis - B4B	12 pcs	9/29/20	9/29/20	0.18	5.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		JK 20-9-15
							HAAS - 4 - B4B		
130	QC 8	12 pcs	9/29/20	9/29/20	0.00	0.00	QC 8 - 12		JK 20/09/20
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S300491



Part: D2857 - 2

Job No: 212567

Serial No/Batch: S300491

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/15/20

Plex 8/26/20 2:49 PM Dart.lajeunesse.marie

140	Handfinish - 1-1 Chemical-B4B	12 pcs	9/29/20	0.00 0.23	QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	QC 7	12 pcs	9/29/20	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	

Handwritten signature and date: 2020/09/25

Handwritten date: 20-09-25

Handwritten numbers: 34 9.89

					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
					QC 7 - 82	
					QC 7 - 87	
160 Powdercoat - 1 White Gl(A)- B4B	12 pcs	9/30/20	0.00 0.16		Powdercoat - 1 - B4B	
<i>M254469.</i> START 11:45. O.C.T: 320° Finish 12:15.					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
170 QC 3	12 pcs	9/30/20	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
					QC 3 - 47	
180 Packaging 3-1 - Stock - B4B	12 pcs	9/30/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	

20-9-25

DAS 34-9-88

SEP 28 2020 DAS 40-9-88

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	12 pcs	9/30/20	0.00 0.00	QC 21 - SA - 21	SEP 29 2020
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
Part Op 100 - (Bandsaw) Cut blanks 4.425" Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FA940 FOLIO REV: _____ 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - QC7-Inspect Chemical Conversion Coat 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ 170 - (QC3- Inspect Part Finish) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.250X2.000	6061T6 Bar 1.250 X 2.000	4.4400 ft (.37 ea)	100-Bandsaw - 1	S216003	X12=4.440
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.250X2.000	4	36	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Bracket	4.300inches $\pm$ 0.010	4.310 4.290	4.300	VERW SL-2
2	Hinge Bracket	4.000inches $\pm$ 0.010	4.010 3.990	4.001	Hx
3	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	.340	VERW -
4	Hinge Bracket	1.110inches $\pm$ 0.005	1.115 1.105	1.110	-
5	Hinge Bracket	1.790inches $\pm$ 0.010	1.800 1.780	1.790	-
6	Hinge Bracket	1.320inches $\pm$ 0.005	1.325 1.315	1.320	-
7	Hinge Bracket	2.000inches $\pm$ 0.010	2.010 1.990	2.001	-
8	Hinge Bracket	0.340inches $\pm$ 0.010	0.350 0.330	.340	-
9	Hinge Bracket	0.447inches $\pm$ 0.010	0.457 0.437	.445	H-6x
10	Hinge Bracket	0.171inches $\pm$ 0.005	0.176 0.171	.173	VERW SL-2
11	Hinge Bracket	0.147inches $\pm$ 0.010	0.157 0.137	.142	-
12	Hinge Bracket	0.376inches $\pm$ 0.010	0.386 0.366	.378	-
13	Hinge Bracket	0.126inches $\pm$ 0.010	0.136 0.116	.123	-
14	Hinge Bracket	0.063inches $\pm$ 0.010	0.073 0.053	.061	-
15	Hinge Bracket	0.166inches $\pm$ 0.005	0.171 0.166	.168	-
16	Hinge Bracket	0.911inches $\pm$ 0.010	0.921 0.901	.907	}
17	Hinge Bracket	0.600inches $\pm$ 0.010	0.610 0.590	.597	
18	Hinge Bracket	0.125inches $\pm$ 0.010	0.135 0.115	.129	
19	Hinge Bracket	0.150inches $\pm$ 0.010	0.160 0.140	.150	

Plex 8/26/20 2:49 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					